

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claims 1-50 (canceled)

1 Claim 51 (previously presented): A method for manufacturing
2 products (1, 30, 40) in a mould, said products comprising at
3 least natural polymers such as starch, wherein said products
4 are manufactured by bringing masses into or through a mold
5 (60, 70, 80) which are heated within said mold, such that
6 this involves at least cross-linkage of the natural
7 polymers, while of at least one first part (6, 36, 85) of
8 the product (1, 30, 40), the material composition is
9 influenced such that the material properties of the relevant
10 first part (6, 36, 85) deviate from the material properties
11 of parts adjoining said part, wherein as masses at least a
12 first mass (M1) and a second mass (M2) are used wherein the
13 first mass (M1) differs in composition from the second mass
14 (M2) prior to introduction into or through said mold (60,
15 70, 80) and wherein the at least one first part (6, 36, 85)
16 of the product (1, 30, 40) is formed from said second mass
17 (M2) and at least one part and preferably all parts (2, 4,
18 32, 36, 87, 89, 48) adjoining the relevant first part (6,
19 36, 85) are formed of said first mass (M1).

1 Claim 52 (previously presented): A method according to
2 claim 51, wherein at least said at least one first part (6,
3 36, 85) in the mold is formed such that a relatively high

4 concentration of softener is obtained and/or maintained
5 herein, such that the flexibility of the relevant at least
6 one first part (6, 36, 85) is greater than the flexibility
7 of parts (2, 4, 32, 36, 87, 89, 48) adjoining said part.

1 Claim 53 (previously presented): A method according to
2 claim 51, wherein the second mass is selected from a group
3 of masses comprising relatively much softener and/or
4 softener retaining components compared to said first mass
5 (M1) such that after the manufacture of the product, so much
6 softener or softener of such nature remains behind in the
7 relevant first part (6, 36, 85) that the pliability thereof
8 is greater than the pliability of wall parts of parts (2, 4,
9 32, 36, 48, 87, 89) adjoining said part made of said second
10 mass (M1).

1 Claim 54 (previously): A method according to claim 51,
2 wherein the second mass is selected from a group of masses
3 comprising relatively little softener or softener retaining
4 components compared to said first mass (M1), such that after
5 the manufacture of the product, such a small amount of
6 softener or softener of such nature remains behind in the
7 relevant first part (6, 36, 85) that the brittleness of at
8 least a part thereof is greater than that of wall parts (2,
9 4, 32, 36, 48, 87, 89) adjoining said part made of said
10 first mass (M1).

1 Claim 55 (previously presented): A method according to
2 claim 51, wherein the first and second masses are selected
3 from groups of masses having different types and/or amounts
4 of fibers, the second mass is selected such that after the
5 manufacture of the product, a concentration and/or

6 orientation of fibers is obtained and/or a type of fibers is
7 included in the relevant first part (3, 36, 85) which
8 deviates from the concentration, orientation and/or nature
9 of any fibers present in other parts (2, 4, 32, 36, 48, 87,
10 89).

1 Claim 56 (previously presented): A method according to
2 claim 51, wherein the first and second masses are selected
3 from groups of masses having different types and/or amounts
4 of blowing agents and/or fillers, the second mass is
5 selected so that at least during the manufacture of the
6 product, a concentration of and/or a type of blowing agent
7 and/or filler is obtained in the relevant first part (6, 36,
8 85) which deviates from that in other parts (2, 4, 32, 36,
9 48, 87, 89) of the product, to obtain a product in which, in
10 the relevant first part (6, 36, 85), a structure is realized
11 whose density deviates from the density of other parts (2,
12 4, 32, 36, 48, 87, 89) of the product.

1 Claim 57 (previously presented): A method according to
2 claim 51, wherein the first and second masses are selected
3 from groups of masses having different types and/or amounts
4 of colorants, wherein the second mass is selected so that in
5 the relevant first part (6, 36, 85), a concentration of
6 and/or a type of colorant is obtained which deviates from
7 that in other parts (2, 4, 32, 36, 48, 87, 89) of the
8 product, to obtain a product in which the relevant first
9 part (6, 36, 85) has a color deviating from that of other
10 parts (2, 4, 32, 36, 48, 87, 89) of the product.

1 Claim 58 (previously presented): A method according to
2 claim 51, wherein the first and second masses are selected

3 from groups of masses having different types and/or
4 concentrations of cross-linkers, wherein the second mass is
5 selected so that at least during the manufacture of the
6 product, a concentration of and/or a type of cross-linkers
7 is obtained in the relevant first part (6, 36, 85) which
8 deviates from that in other parts (2, 4, 32, 36, 48, 87, 89)
9 of the product, to obtain a product in which the relevant
10 first part (6, 36, 85) has a structure whose density
11 deviates from the density of other parts (2, 4, 32, 36, 48,
12 87, 89) of the product.

1 Claim 59 (previously presented): A method according to
2 claim 51, wherein the second mass is introduced between two
3 flows of first mass.

1 Claim 60 (previously presented): A method according to
2 claim 51, wherein the second mass is introduced into a mold
3 in a zone forming the relevant first part (6, 36, 85), while
4 the first mass is introduced into a number of zones forming
5 parts (2, 4, 32, 36, 48, 87, 89) adjoining said first zone,
6 such that in the closed mold, the first mass and the second
7 mass are forced against each other and interconnected.

1 Claim 61 (previously presented): A method according to
2 claim 51, wherein the first and the second mass in the mold
3 are interconnected prior to or at the start of the
4 occurrence of cross-linkage of the natural polymers.

1 Claim 62 (previously presented): A method according to
2 claim 51, wherein the first mass and the second mass are
3 introduced into the mold out of phase, while preferably the

4 introduction of the second mass is started prior to the
5 introduction of the first mass.

1 Claim 63 (previously presented): A method according to
2 claim 51, wherein the first mass in the mold is subjected to
3 a first pressure and the second mass in the mold is
4 subjected to a second pressure, the first pressure deviating
5 from the second pressure.

1 Claim 64 (previously presented): A method according to
2 claim 51, wherein the or each mass is introduced into the
3 mold under a pressure higher than atmospheric, preferably
4 through injection molding.

1 Claim 65 (previously presented): A method according to
2 claim 51, wherein at least three different masses are used
3 for the manufacture of the product.

1 Claim 66 (previously presented): A method according to
2 claim 51, wherein at least the at least one first part (6,
3 36, 85), after formation in the mold, is processed such that
4 the material properties of said relevant first part (6, 36,
5 85) are changed, at least relative to parts (2, 4, 32, 36,
6 48, 87, 89) adjoining said part (6, 36, 85).

1 Claim 67 (previously presented): A method according to
2 claim 51, wherein to at least a portion of the at least one
3 first part (6, 36, 85), a first coating is applied, said
4 coating comprising at least a component active with the
5 relevant first mass, such that between the relevant active
6 component and the mass, there is obtained a reaction whereby

7 the material properties of the relevant first part (6, 36,
8 85) are influenced.

1 Claim 68 (previously presented): A method according to
2 claim 67, wherein at least the parts (2, 4, 32, 36, 48, 87,
3 89) adjoining the first part (6, 36, 85) are covered prior
4 to the application of the first coating.

1 Claim 69 (previously presented): A method according to
2 claim 68, wherein parts (2, 4, 32, 36, 48, 87, 89) adjoining
3 the first part (6, 36, 85) are at least partially covered by
4 a second coating, substantially impermeable to said reactive
5 component of the first coating, such that the first part (6,
6 36, 85) is at least partially kept clear of the second
7 coating.

1 Claim 70 (previously presented): A method according to
2 claim 69, wherein a second coating is used having a high
3 hardness relative to the first coating, a relatively low
4 permeability and high resistance to at least said reactive
5 component.

1 Claim 71 (previously presented): A method according to
2 claim 69, wherein the first coating is applied over the
3 second coating.

1 Claim 72 (previously presented): A method according to
2 claim 67, wherein as first coating, a water-based coating is
3 used.

1 Claim 73 (previously presented): A method according to
2 claim 67, wherein as first coating, a relatively flexible,
3 elastic coating is used.

1 Claim 74 (previously presented): A method according to
2 claim 67, wherein as first coating, a coating is used
3 comprising a number of constituents from the group of:
4 acrylic binders, latices, styrene-butadiene latex,
5 polyvinyl alcohol, polyvinyl acetate, polyacrylates,
6 polyethylene glycol, polylactic acid, synthetic polymers,
7 natural polymers, natural waxes, synthetic waxes (for
8 instance ionic polyethylene waxes) or derivatives thereof or
9 combinations of the preceding.

1 Claim 75 (previously presented): A method according to
2 claim 69, wherein as second coating, a coating is used
3 comprising a number of constituents from the group of:
4 melamine, acrylic binders, water-resistant lacquers
5 (for instance cellulose lacquer), cellulose acetate
6 propionates, polyethylene, polyacrylates, synthetic
7 polymers, natural polymers, synthetic waxes, natural waxes,
8 polylactic acid, derivatives thereof or combinations of the
9 preceding.

1 Claim 76 (previously presented): A method according to
2 claim 74, wherein cross-linkers are incorporated into the
3 first and/or second coating, in particular from the group of
4 zirconium acetate, ammonium zirconium carbonate, urea
5 formaldehyde, melamine formaldehyde, glyoxal,
6 polyamideamine-epichlorohydrin, epoxides, trimetaphosphate,
7 derivatives thereof or combinations of the preceding.

1 Claim 77 (previously presented): A method according to
2 claim 74, wherein in the first coating, at least one of the
3 waxes is combined with at least one of the said other
4 constituents.

1 Claim 78 (previously presented): A method according to
2 claim 74, wherein the first, respectively second coating is
3 formed almost entirely from one of said constituents.

1 Claim 79 (previously presented): A method according to
2 claim 51, wherein the first part (6, 36, 85) is designed as
3 a hinge part 6 having at least one recess, in particular at
4 least one groove extending over the width of the hinge part
5 is provided.

1 Claim 80 (previously presented): A method according to
2 claim 51, wherein into the first part (6, 36, 85), after
3 cross-linking of the natural polymers, a softener is
4 introduced.

1 Claim 81 (previously presented): A method according to
2 claim 51, wherein a reactive component is incorporated into
3 the first part (6, 36, 85), outside the mold, while it is at
4 least substantially prevented from flowing away to the other
5 parts, preferably a softener having a relatively large
6 particle size and/or high viscosity.

1 Claim 82 (previously presented): A method according to
2 claim 81, wherein as reactive component, at least a fatty,
3 oily or waxy ingredient or the like is used.

1 Claim 83 (previously presented): A method according to
2 claim 51, wherein as softener, at least one from the
3 following group is used: water, polyols, glycol, glycerol,
4 glycerin, polyethylene glycol, polypropylene glycol,
5 propylene glycol, sorbitol, glucose, derivatives thereof or
6 combinations of preceding softeners.

1 Claim 84 (previously presented): A method according to
2 claim 51, wherein at least during a portion of the
3 cross-linking of the natural polymers, the first part is at
4 least partially compressed.

1 Claim 85 (previously presented): A method according to
2 claim 51, wherein in or on at least the first part, an
3 active component is provided for adjusting the surface
4 tension of at least said first part of the product with
5 cross-linked natural fibers, in particular for increasing
6 the surface tension.

1 Claim 86 (previously presented): A method according to
2 claim 51, wherein to at least a part of the product, a
3 coating is applied whose surface tension is approximately
4 equal to or lower than the surface tension of the product
5 part to which the coating is applied.

1 Claim 87 (previously presented): A method according to
2 claim 51, wherein a coating is applied to the product, said
3 coating comprising cross-linkers for the mass, in particular
4 natural polymers incorporated therein.

1 Claim 88 (previously presented): A method according to
2 claim 51, wherein at least two coatings are applied at least

3 partially one over the other, at least one of the coatings
4 comprising an active component capable of reacting with the
5 at least one other coating.

1 Claim 89 (previously presented): A method according to
2 claim 88, wherein as active component, at least
3 cross-linkers are used.

1 Claim 90 (previously presented): A method according to
2 claim 67, wherein the product is gripped at the first part
3 (6, 36, 85), such that it is covered at least substantially
4 completely, after which the second coating is applied to
5 other parts (2, 4, 32, 36, 48, 87, 89), in particular
6 sprayed thereon, after which the first part is released and,
7 after that, the second coating is applied, in particular
8 sprayed thereon.

Claims 91-100 (canceled)